

Work Order ID 81628

81628

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Friday, March 16, 2012 10:08:55 AM

Item ID: D3874-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector
 Start Date: 3/15/2012 Start Qty: 2.00 ***2*4.** Cust Item ID:
 Required Date: 3/21/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-03-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3874	A								

100 0.00
100
 HandThermo Memo 0.00 x4 Wk
 Hand Finishing Thermoforming 1-Cut Sheet to required Blank size 12/03/20

105 0.00
105
 HandThermo Dry Material Memo 0.00 x4 Wk
 Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE 12/03/20
 Temp: 240° F
 Time IN: 7:00 pm 12/03/19
 Time OUT: 5:00 am 12/03/20

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/15/2012 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 3/21/2012 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

110

0.00

Thermoform

Thermoforming Machine

Memo

- 1-Machine Set-Up
- 2-Pre-heat Tool to required temp.
- 3-Thermoform as per Dwg and Folio #FTA039 using tool DT9474

Dwg Rev: A

Folio Rev: 8

0.00

120

0.00

OC

Quality Control

Memo

Visually inspect part for proper formation and texture

0.00

130

0.00

QC

Quality Control

Picklist Print

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Work Order ID: 81628
Parent Item: D3874-2
Parent Item Name: Floor Protector

Start Date: 3/15/2012 Required Date: 3/21/2012
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Material 10/04/21 DL IPP Rev B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	1,458.7869	4.38	8.76			

Location

therm

113127

Loc Qty

1458.786941

1458.78694

Loc Code

17.52 *sg ft*

DR
12/03/21

DART AEROSPACE LTD		Work Order: 81608
Description: Floor Protector		Part Number: D3874-1
Inspection Dwg: D3874	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>Dh.</u>	Date: <u>12/03/20</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.060"	✓		Vern DL-02	
0.065	Min	0.103"	✓		CAL TH-05	
0.5	Min	0.56"	✓		Vern DL-02	

Measured by: <u>Dh.</u>	Date: <u>12/03/21</u>
Audited by: <u>EE</u>	Date: <u>12-03-21</u>
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>[Signature]</u>

8 7 6 5 4 3 2 1

D

D

C

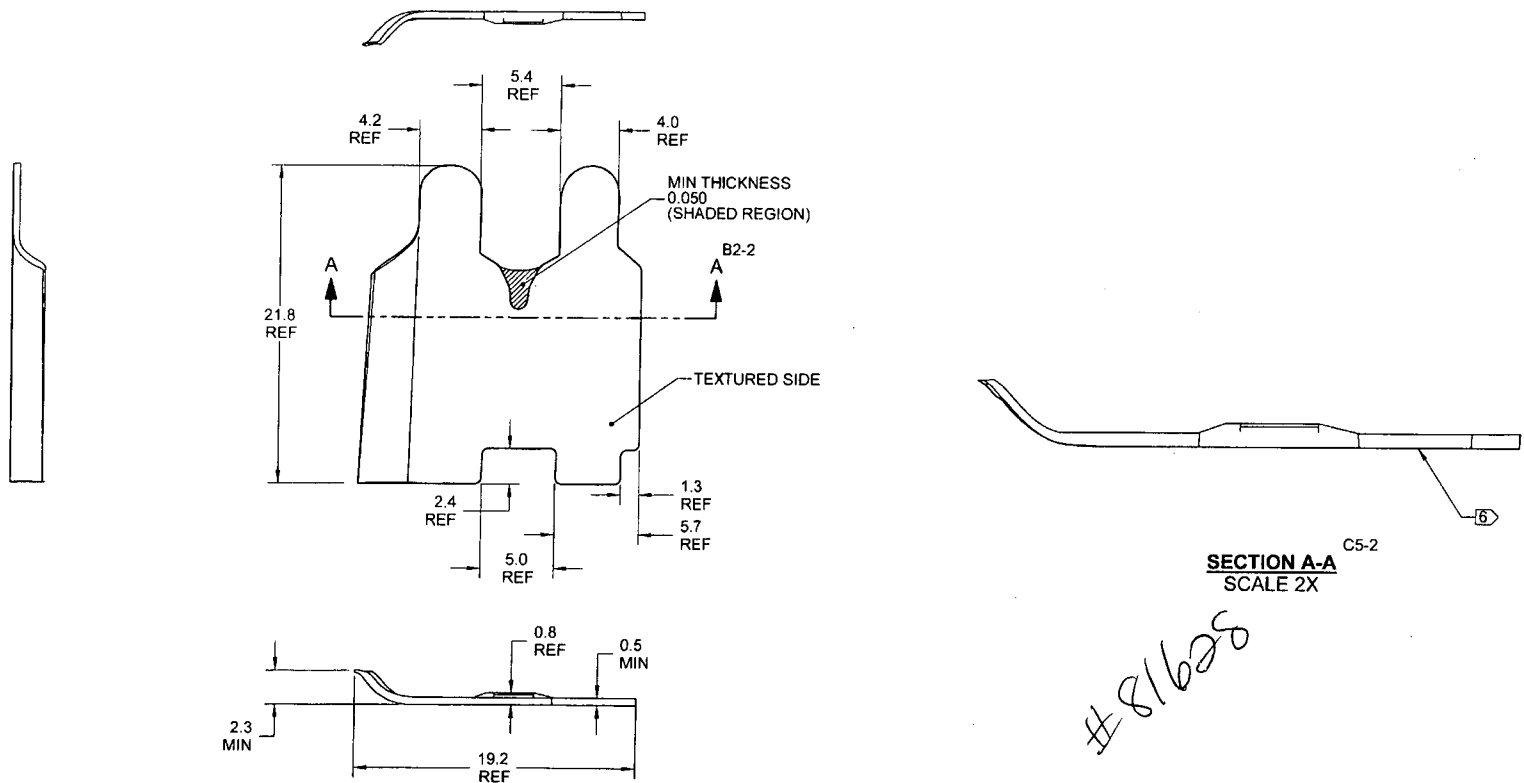
C

B

B

A

A



D3874-1 FLOOR PROTECTOR

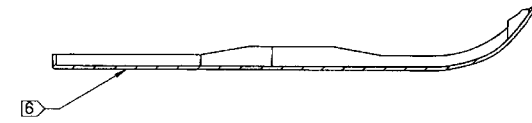
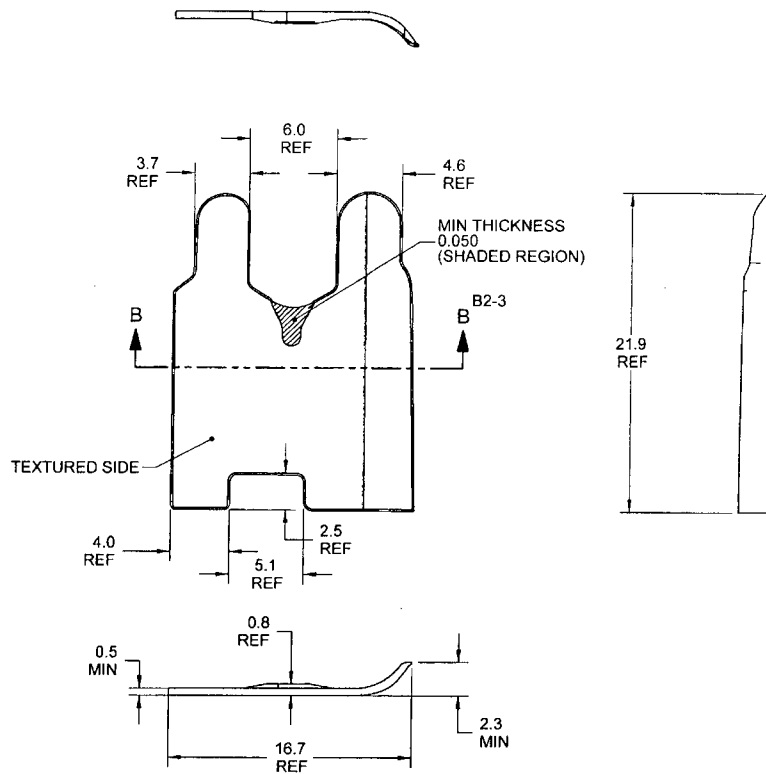
RELEASED
09/25/05

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

DESIGN	PAH	DART AEROSPACE LTD	
DRAWN	PAH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PAH	DRAWING NO. D3874	REV. A
MFG. APPR.	PAH	TITLE	SHEET 2 OF 3
APPROVED	PAH	FLOOR PROTECTOR	SCALE
DE APPR.	PAH		NTS
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8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN	AB	DART AEROSPACE LTD	
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	AB	D3874	SHEET 3 OF 3
APPROVED	AB	TITLE	SCALE
DE APPR.	AB	FLOOR PROTECTOR	NTS
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2/15/05